

5/30

65.

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23620
<b>Description:</b> Support Assembly		<b>Part Number:</b>	D3278-041
<b>Dwg:</b> D3278 Rev. <i>REF 05.06.07</i>		<b>Qty:</b>	38 <del>40</del>
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <i>DWG NOT REQUIRED 04.07.05</i>	<i>HA</i>	05.06.21	40																				
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) <b>Identify for D3278-1</b> Batch: <i>M15449</i>	<i>E</i>	05/07/14	40																				
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) <b>Identify for D3278-2</b> Batch: <i>M1549</i>	<i>E</i>	05/07/14	40																				
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 <b>Identify as D3278-1</b>	<i>E</i>	05/07/15	40																				
5	QC2	Inspect parts as they come off the CNC machine	<i>E</i>	05.07.15	40																				
6	MV	Deburr and Tumble	<i>E</i>	05/07/15	40																				
7	QC8	Second check	<i>E</i>	05.07.16	40																				
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 <b>Identify as D3278-2</b>	<i>E</i>	05/07/16	40																				
9	QC2	Inspect parts as they come off the CNC machine	<i>E</i>	05.07.16	40																				
10	MV	Deburr and Tumble	<i>E</i>	05.07.16	40																				
11	QC8	Second check	<i>E</i>	05.07.16	40																				
12	FP	Acid etch and Alodine as per QSI 005 4.1	<i>SAD</i>	05-8-11	40																				
13	QC5	Inspect work to Step 12	<i>J</i>	05-08-14	40																				
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	<i>ML</i>	05 09 20	40																				
15	QC3	Inspect Powder Coat	<i>SB</i>	05/09/21	40																				
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) <b>Pick: Packing Kit</b> <table><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3278-1</td><td>Support</td><td><i>A 23620</i></td></tr><tr><td>1</td><td>D3278-2</td><td>Support</td><td><i>B 23620</i></td></tr><tr><td>1</td><td>D3278-3</td><td>Spacer</td><td><i>B 22971</i></td></tr><tr><td>4</td><td>MS20426AD3-87</td><td>Rivet</td><td><i>M 17694</i></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D3278-1	Support	<i>A 23620</i>	1	D3278-2	Support	<i>B 23620</i>	1	D3278-3	Spacer	<i>B 22971</i>	4	MS20426AD3-87	Rivet	<i>M 17694</i>	<i>SB</i>	05/09/22	39
Qty	Part Number	Description	Batch																						
1	D3278-1	Support	<i>A 23620</i>																						
1	D3278-2	Support	<i>B 23620</i>																						
1	D3278-3	Spacer	<i>B 22971</i>																						
4	MS20426AD3-87	Rivet	<i>M 17694</i>																						
17	QC5	Inspect work to Step 16	<i>J</i>	05-09-22	38																				

*05.06.07*



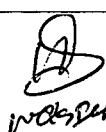
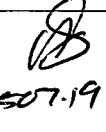
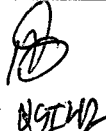
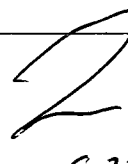

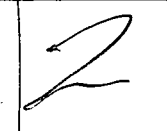
*p10*

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RELEASED

*04.04.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/07/15	#4	3 parts (DS270-1) scrap setup problems (ED)		Fixed Problems SCRAP + Replace	ED 05/07/15	 0507-19		 0507-19
05/09/22	16	removed rivet MS20426 AD 4-7 because were too long + 2 part hole was over tolerance		Scrap.	SB 05/09/22	 05-09-22		 05-09-22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 05/09/22

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23620
<b>Description:</b> Support Assembly		<b>Part Number:</b>	D3278-041
<b>Dwg:</b> D3278 Rev. A <i>APB 05.06.07</i>		<b>Qty:</b>	40
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																				
18	GA	Assemble support as per Dwg D3278 <b>Pick: Packing Kit</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>D2230-1</td><td>Clamp</td><td>B22163e</td></tr><tr><td>2</td><td>AN4-13A</td><td>Bolt</td><td>M17404</td></tr><tr><td>4</td><td>AN960JD416</td><td>Washer</td><td>M17566</td></tr><tr><td>2</td><td>MS21042L4</td><td>Nut (or -4)</td><td>M15924</td></tr></table> <b>Identify as D3278-041 Do NOT Tighten Bolts.</b>	Qty	Part Number	Description	Batch	2	D2230-1	Clamp	B22163e	2	AN4-13A	Bolt	M17404	4	AN960JD416	Washer	M17566	2	MS21042L4	Nut (or -4)	M15924	SB	05/09/20	38
Qty	Part Number	Description	Batch																						
2	D2230-1	Clamp	B22163e																						
2	AN4-13A	Bolt	M17404																						
4	AN960JD416	Washer	M17566																						
2	MS21042L4	Nut (or -4)	M15924																						
19	QC5	Inspect work to Step 18	2	05.09.26	38																				
20	ST	Identify and Stock	CL	05/09/26	38																				
21	AC	Cost / part 61.17	545	05.09.29	38																				
22	DC	Close W/O 55.94 Inspect Level 21	FD	05/09/27	38																				

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>04.04.22</i>

**RELEASED**  
*04.04.22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	23620
Description: Support		Part Number:	D3278-1
Inspection Dwg: D3278	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.359	+/-0.005	0.356	✓			
0.648 <del>0.609</del>	+/-0.010	0.613	✓			
0.250	+/-0.010	0.250	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	0.125	✓			
0.119	+0.005/-0.004	0.118/0.120	✓			
2.439	+/-0.010	2.435	✓			
1.980	+/-0.010	1.985	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.873	✓			
0.500	+/-0.010	0.504	✓			
R0.400	+/-0.010	0.400	✓			
1.720	+/-0.010	1.725	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.120	✓			

Measured by: <i>Er</i>	Audited by: <i>gml</i>	Prototype Approval:	N/A
Date: 05/07/14	Date: 05/07/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

**RELEASED**  
05.06.08

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23620
<b>Description:</b> Support		<b>Part Number:</b>	D3278-2
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓			
0.359	+/-0.005	0.350	✓			
<del>0.615</del> 0.609	+/-0.010	0.613	✓			
0.250	+/-0.010	0.250	✓			
1.480	+/-0.005	1.481	✓			
R0.125	+/-0.010	0.125	✓			
0.119	+0.005/-0.004	0.120	✓			
2.439	+/-0.010	2.441	✓			
1.980	+/-0.010	1.985	✓			
R0.130	+/-0.010	0.130	✓			
Ø0.257	+0.005/-0.000	0.257	✓			
R0.375	+/-0.010	0.375	✓			
0.875	+/-0.010	0.873	✓			
0.500	+/-0.010	0.499	✓			
R0.400	+/-0.010	0.400	✓			
1.720	+/-0.010	1.723	✓			
R0.125	+/-0.010	0.125	✓			
0.125	+/-0.010	0.127	✓			

<b>Measured by:</b>	ES	<b>Audited by:</b>	RG	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	05/07/15	<b>Date:</b>	05.07.15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue      P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	

**RELEASED**  
 05/07/15

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 20, 2005  
03:23 pm

Work Order No : 0023620  
Project Name : D3278-041  
Project For : WK530  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3278-041  
Description : Support Assembly  
Manufactured : Yes  
Amount Req'd : 40  
Amount Done : 0  
Start Date : 06-20-05  
Est Finish Date : 07-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00